

Work Order ID 67965

Page 1

Tuesday, April 05, 2011 10:11:31 AM

Item ID: DSI 9448-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Upgrade

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: AL Date: 11-04-5 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



DC

Document Control

Memo

Photocopy bluefile and create labels per PPP DSI 9448-011

CHG 001

8/11/05/12

11-04-5

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

JB

11/04/20

120

QC4- 100% inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/11/05/12

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 4/5/2011 Start Qty: 1.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per APP DSI 9448-011								
	Location: 20 Draft								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/08

11/5/10
cmf

11-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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1. **What is the purpose of the study?**
 2. **What are the research objectives?**
 3. **What is the research design?**
 4. **What are the variables?**
 5. **What is the sample size?**
 6. **What are the data sources?**
 7. **What are the data collection methods?**
 8. **What are the data analysis methods?**
 9. **What are the results?**
 10. **What are the conclusions?**
 11. **What are the limitations?**
 12. **What are the implications?**
 13. **What are the future research directions?**
 14. **What are the references?**
 15. **What are the appendices?**
 16. **What are the glossary?**
 17. **What are the abbreviations?**
 18. **What are the acknowledgments?**
 19. **What are the funding sources?**
 20. **What are the ethical considerations?**
 21. **What are the conflicts of interest?**
 22. **What are the disclosures?**
 23. **What are the disclosures of potential conflicts of interest and any competing financial interests or competing non-financial interests?**
 24. **What are the disclosures of potential conflicts of interest and any competing financial interests or competing non-financial interests?**
 25. **What are the disclosures of potential conflicts of interest and any competing financial interests or competing non-financial interests?**



Required Date: 4/11/2011

Required Qty: 1.00

[illegible]

11/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:11:37 AM

Work Order ID: 67965

Parent Item: DSI 9448-011

Parent Item Name: Hinge Upgrade

Start Date: 4/5/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-22A

Purchased

No

110

Each

165.0000

1

1 ✓



Bolt

JB

Location

Loc Qty

Loc Code

ST359

165

114523

15

114784

100

116419

50

114523

AN4-24A

Purchased

No

110

Each

18.0000

1

1 ✓



Bolt

JB

Location

Loc Qty

Loc Code

ST359

18

115835

18

115835

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

8

8 ✓



Washer

117065 JB

AN970-4

Purchased

No

110

Each

80.0000

4

4 ✓



Washer

JB 11/04/20

Location

Loc Qty

Loc Code

ST344

16

115936

16

ST349

64

116900

64

116900

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Tuesday, April 05, 2011 10:11:37 AM

Work Order ID: 67965

Parent Item: DSI 9448-011

Parent Item Name: Hinge Upgrade

Start Date: 4/5/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

3,160.000

5

5 ✓



Nut



JB

Location

Loc Qty

Loc Code

ST300

3160

116188

1160

116823

2000

116188

NAS43DD4-46N

Purchased

No

110

Each

78.0000

3

3 ✓



SPACER



JB 11/04/2011

Location

Loc Qty

Loc Code

ST279

78

111886

78

111886

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-540 REV. 1

REF CANADIAN STC: SH94-5

REF FAA STC: SR00386NY

REF GERMAN STC: LBA RC 1124

THIS DART SERVICE INSTRUCTION PROVIDES GUIDELINES TO REPLACE THE EXISTING HINGE PLATES WELDED ON THE BASKET BASE AND LID OF D206-540-011/-013 HELI-UTILITY-BASKET AT CHG 004/CHG 003 RESPECTIVELY WITH D3748-1 AND D3749-1 HINGE HALVES TO ELIMINATE POSSIBLE INTERFERENCE BETWEEN THE BASKET INSTALLATION AND THE CABIN DOOR.

REFERENCE ONLY
5

REPLACEMENT PROCEDURE:

- 1) REMOVE PROP ARM FROM LID AND SEPERATE LID FROM BASE.
- 2) TRIM HINGE PLATES FLUSH TO LID/BASE FRAME AS SHOWN IN FIGURE 1. DEBURR.
- 3) REMOVE PAINT IN AREAS WHERE THE NEW D3748-1 (BASE) AND D3749-1 (LID) HINGE HALVES WILL BE WELDED. REFER TO VIEWS A-A AND B-B.
- 4) LOCATE QTY(3) D3748-1 ON BASE AS SHOWN IN VIEW A-A AND TIG WELD PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD.
- 5) POSITION AND CENTER LID ON BASE. SHIM LID BY 0.200". REFER TO VIEW B-B.
- 6) LOCATE QTY(3) D3749-1 ON LID AS FOLLOWS: CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON BASKET BASE ASSEMBLY AND TIG WELD PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD. REFER TO VIEW B-B.
- 7) TRANSFER DRILL Ø0.261" HOLE FROM D3748-1 TO D3749-1. DEBURR. REFER TO VIEW D-D.
- 8) TOUCH UP PAINT/AFFECTED REPAIRED AREAS ON BOTH LID AND BASE WITH ONE COAT OF MIL-P-85582 OR MIL-P-23377 PRIMER AND 2-3 COATS OF MIL-C-85285 POLYURETHANE PAINT TO MATCH ORIGINAL FINISH.
- 9) INSTALL LID ON BASE IN ACCORDANCE WITH FIGURE 2.
- 10) REFASTEN PROP ARM TO LID.

PARTS LIST:

Qty	Part No.	Description
X	DSI 9448-011	HINGE UPGRADE KIT
3	D3748-1	HINGE HALF
3	D3749-3	HINGE HALF
6	D3723-1	BUSHING
3	AN4-20A	BOLT
1	AN4-22A	BOLT
1	AN4-24A	BOLT
8	AN960JD416	WASHER
4	AN970-4	WASHER
5	MS21042L4	NUT (OR MS21042-4)
3	NAS43DD4-46	SPACER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.02.12
CERT. NO.: SH94-5
ISSUE NO.: 4

A	NEW ISSUE	MB	09.02.12
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9448	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE UPGRADE KIT	NTS
DATE	09.02.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

